

Work Order ID 74512

Monday, October 03, 2011 2:37:31 PM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: M.C.J ✓

Date: 11/10/03 Tooling:

Date: _____

Run Start



QC:

Date: _____ SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

B11-10-27

FLOW CNC Waterjet

304-040

I-Cut as per Dwg D3535

 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

B11-10-28

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B11-10-27

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Sul10128

12

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 □ 2-Form
joggle as per Dwg D3535 using Jig DT8158 □ 3-Identify as D3535-15

Sp 11/10/31

17

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

M 11 10 31 12

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

3245 0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

□ FINISH TIME:

12/10/11 11/10/11

M118436

320° F

475

Dart Aerospace Ltd

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Page 3

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Cust Item ID:

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BK 10-11-2

170

Identify as per dwg & Stock Location: FP-1

0.00



Packaging

Memo

0.00

Packaging

12 BK 10-11-2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/2011

10/11/11
(12)

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 2:37:36 PM

Page 1

Work Order ID: 74512



Parent Item: D3535-15



Parent Item Name: Wearshoe

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	170.5795	1.0205	12.89053		<u>10/03/11</u>	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	170.5795	
116623	0.2	
117550	8.363	
117933	45.3442	
118400	33.6723	
118964	83	
<u>119346</u>		<u>119346</u>

(12)

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	74512
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	>		V 1B02	
2.000	+/-0.010	2.003	>		V	
5.650	+/-0.010	5.656	<		T 1B01	
9.150	+/-0.010	9.156	<		T	
14.400	+/-0.010	14.406	<		T	
19.650	+/-0.010	19.656	<		T	
24.900	+/-0.010	24.906	<		T	
30.150	+/-0.010	30.156	>		T	
33.650	+/-0.010	33.656	<		T	
35.650	+/-0.010	35.656	<		T	
39.150	+/-0.010	39.156	<		T	
Ø0.188	+0.005/-0.001	.191	,		V	
24.00	+/-0.030	24.006	~		T	
16.00	+/-0.030	16.00	<		T	
8.00	+/-0.030	8.06	<		T	
5.00	+/-0.030	5.00	>		T	
0.300	+/-0.010	.304	<		V	
0.300	+/-0.010	.305	>		V	
0.038	+/-0.010	.038	>		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-10-17	Date:	11/10/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

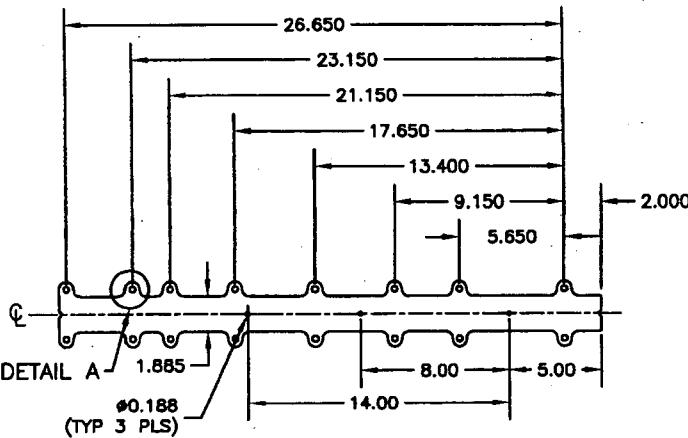
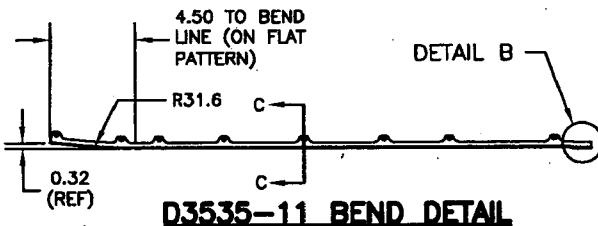
Dart Aerospace Ltd

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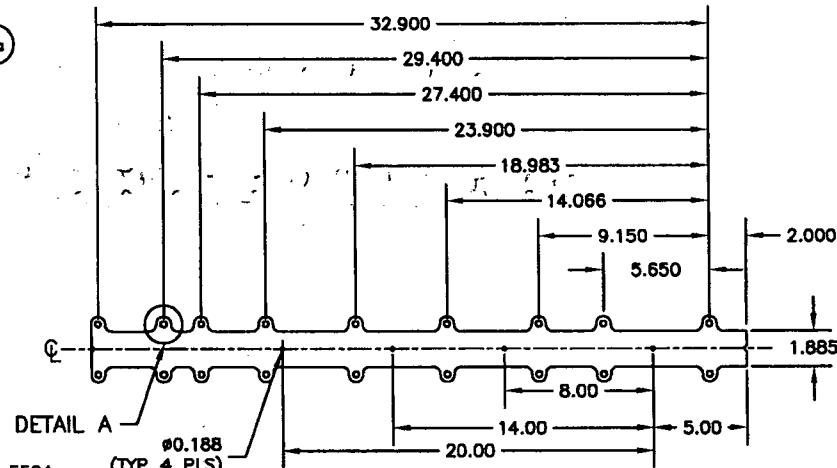
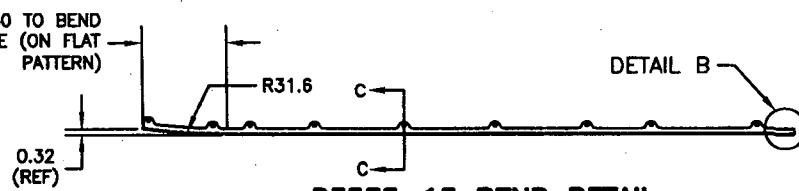
NOTE: Date & initial all entries

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74512 M.L.J

11/10/03

RELEASED
07.04.24
H

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
DATE		TITLE	SCALE
07.04.17		D3535	
A		WEARSHOE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	1:10

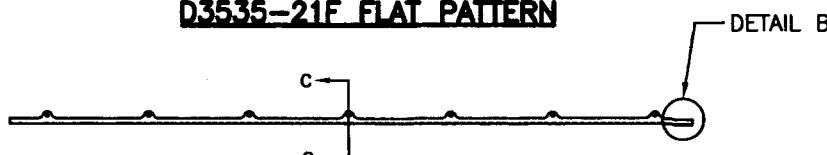
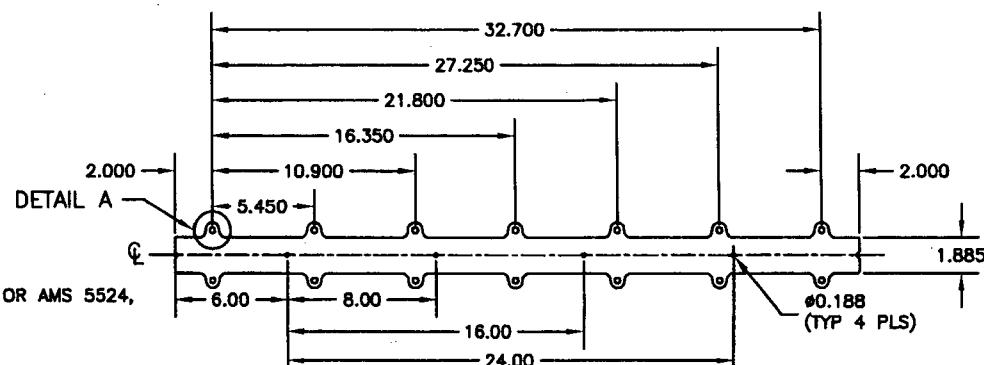
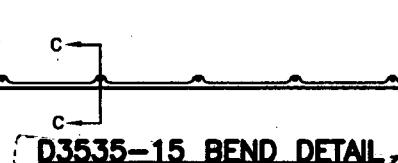
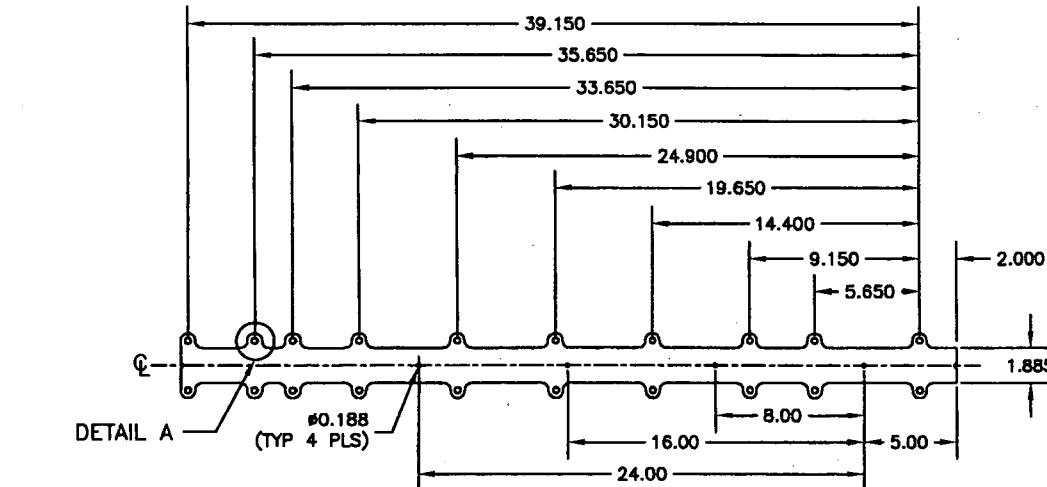
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74512

DARTRELEASED
07.04.17**NOTES**

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
C8	PH	
CHECKED	APPROVED	DRAWING NO.
7/4/17	7/4/17	D3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B		SHEET 2 OF 7
SCALE		1:10

Dart Aerospace Ltd

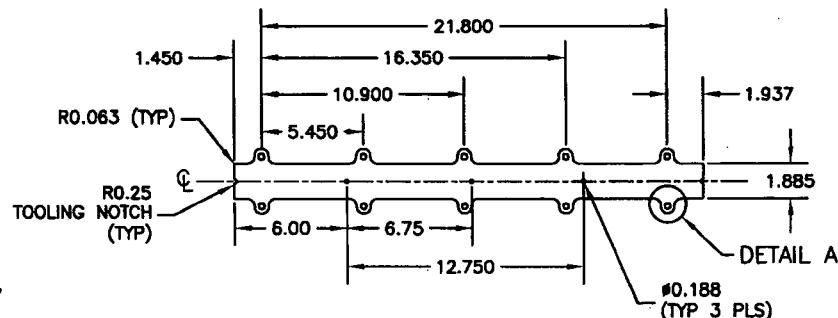
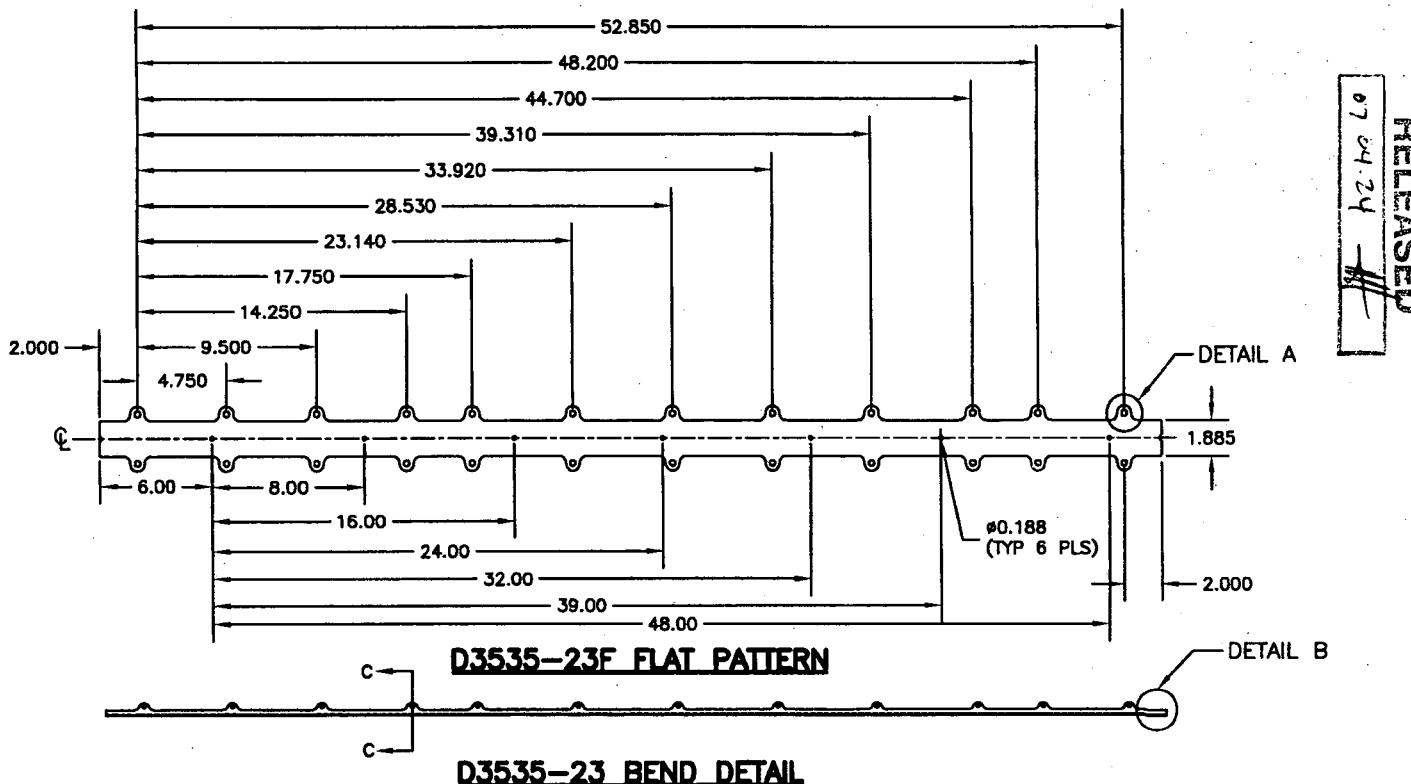
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74512

DART**NOTES**

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C8	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>W</i>	<i>W</i>	D3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B		SHEET 3 OF 7
		SCALE
		1:10

Dart Aerospace Ltd

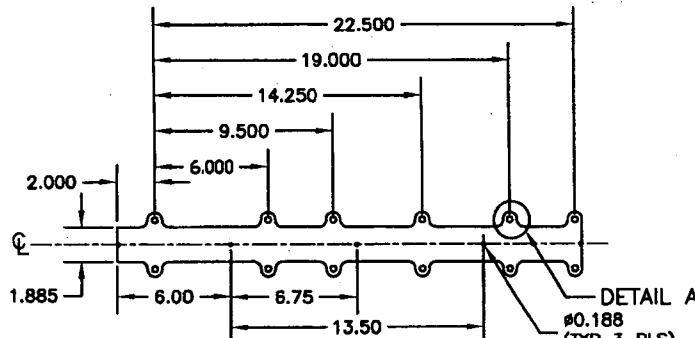
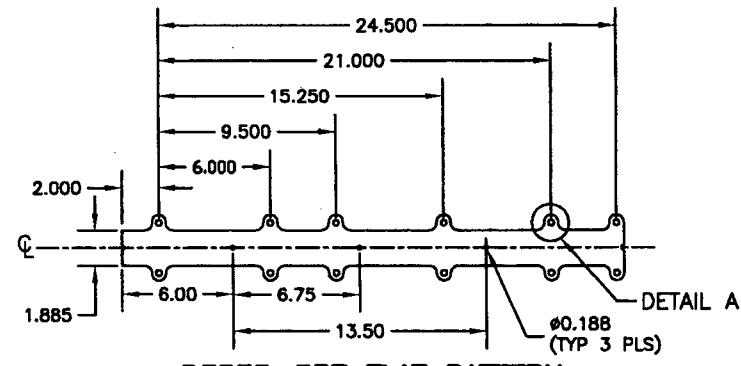
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74512

DARTRELEASED
07.04.17**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

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NOTES

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DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

REV. B
SHEET 4 OF 7
SCALE 1:10

Dart Aerospace Ltd

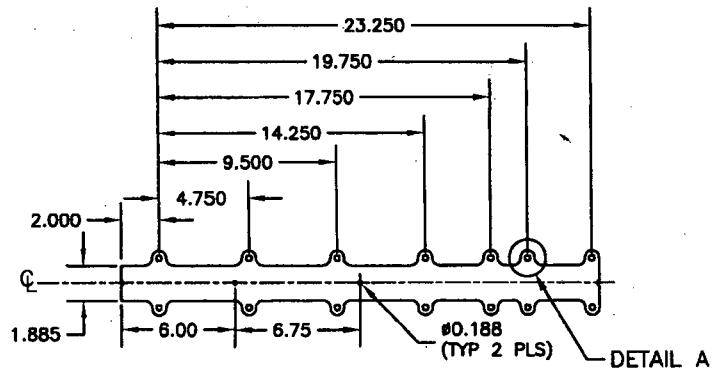
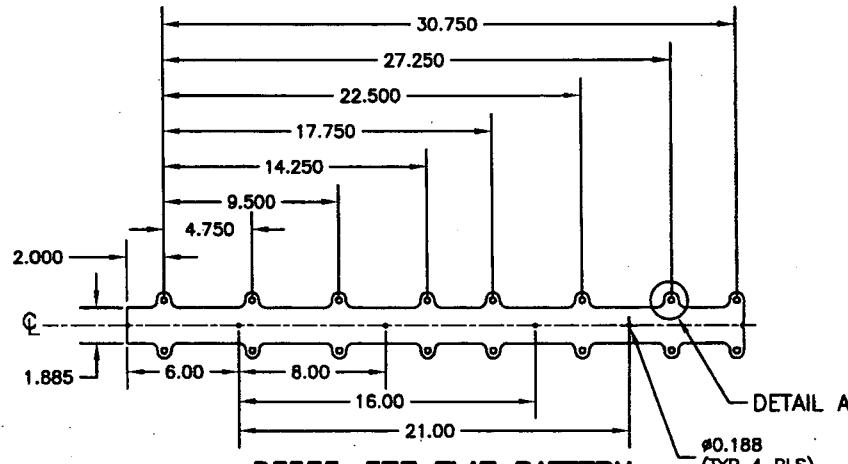
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DARTRELEASED
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

DESIGN CB	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7 SCALE 1:10

NOTES

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Dart Aerospace Ltd

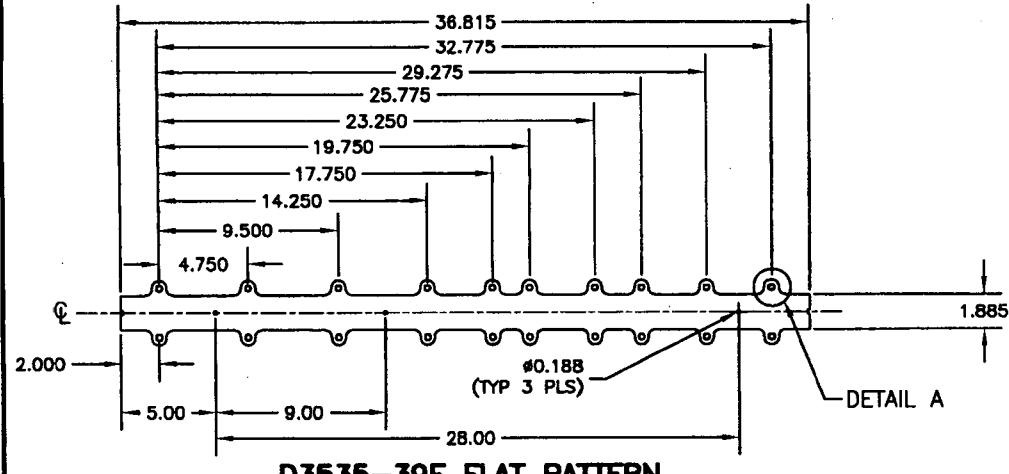
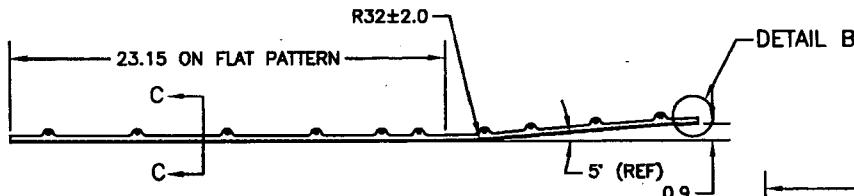
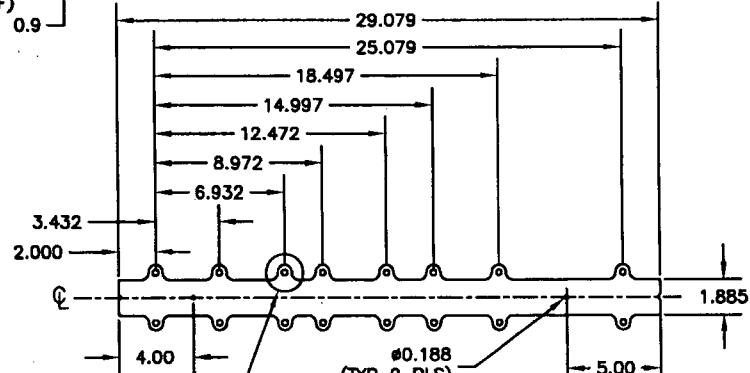
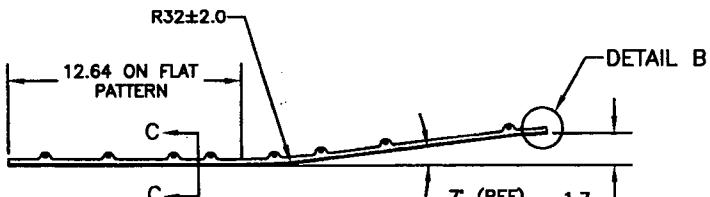
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74518

DARTRELEASED
07.04.17**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

DESIGN CB	DRAWN BY RH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10

NOTES

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Dart Aerospace Ltd

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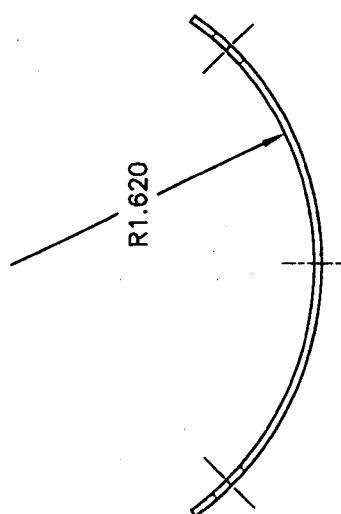
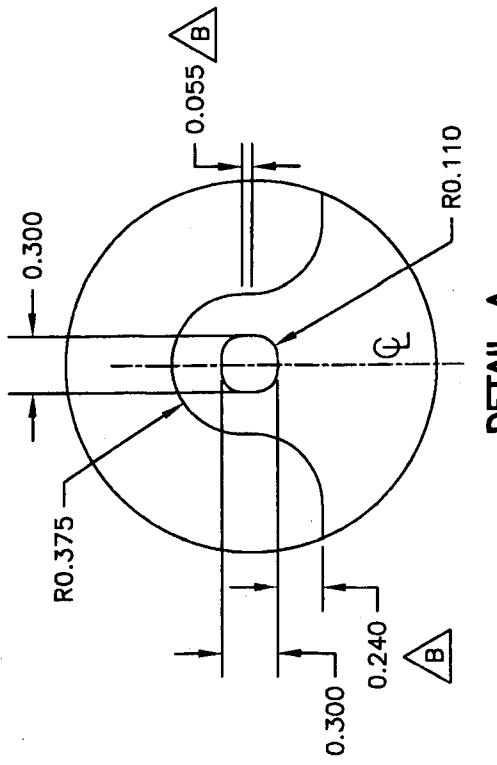
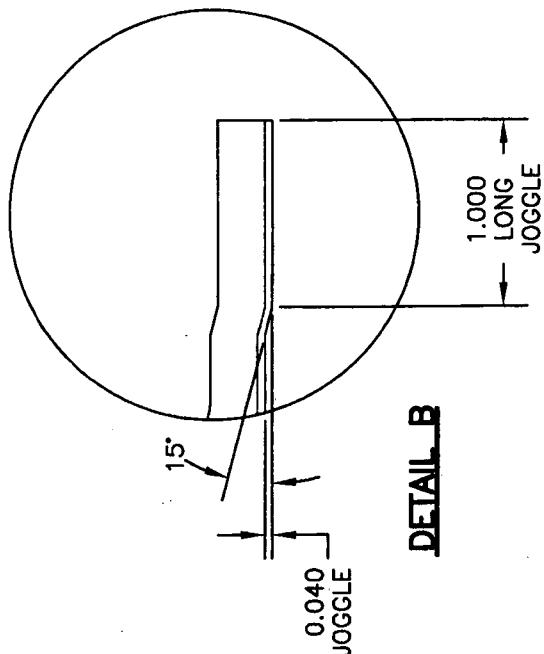
NOTE: Date & initial all entries

DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535
DATE 07.04.17		REV. B SHEET 7 OF 7 TITLE WEARSHOE SCALE 1:1

RELEASED

07.04.24



SECTION C-C

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries